

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014428**Date Inspected:** 27-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard:

CB11, CB12, CB13 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

CB14:

This QA Inspector observed the following work in progress:

Repair welding of weld joint nos: FB204-042-063 & 065. Welder was identified as 055564. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC Quality Control (QC) is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-repair [welding repair report (WRR) no: B-WR13008 Rev-0 & B-WR 13010 rev:0].

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Trial Assembly:

CB7, CB8, CB9 & CB10:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 14:

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joints SEG3004C-PP112-174 & 175 (for OBG SEG 12 AW). Welders are identified as 066179 & 067764. ZPMC QC is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

SMAW of weld joints SEG3006N-PP115-021 (for OBG SEG 12 CW). Welder is identified as 062438. ZPMC QC is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4b-F.

Bay 19:

This QA Inspector observed the following work in progress:

FCAW of weld joints SB013-062-001 (for OBG component Suspender Bracket SB62W). Welder is identified as 062738. ZPMC QC is identified as Zhong Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

FCAW of weld joints SB013-066-001 (for OBG component Suspender Bracket SB66W). Welder is identified as 062749. ZPMC QC is identified as Zhong Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Notification No: 005791.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG component – Bottom Panel BP026-014 & BP025. The weld designations reviewed are as follows:

- 1) BP026-014-004, 005, 022, 023, 014, 015, 044, 045, 053.
- 2) BP025-015-049, 052, 053, 014, 015, 020, 021, 022 & 023.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
